

# Work Order ID 76074

**\*76074\***

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Friday, November 04, 2011 2:59:22 PM

Item ID: D2583 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Latch Bracket  
 Start Date: 11/4/2011 Start Qty: 40.00 **\*40\*** Cust Item ID:  
 Required Date: 11/11/2011 Req'd Qty: 40.00 **\*40\*** Customer:

## Reference:

Approvals: Process Plan: *R* Date: 11-11-07 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
 Run Start **\*NR1\***  
 Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2583	Rev B								

100 0.00  
**\*100\*** FLOW WATER JET  
 Waterjet Memo 0.00  
 FLOW CNC Waterjet 1-Cut as per Dwg D2583 Dwg Rev: B Prog Rev: B 2-  
 5052.040 Debur if necessary

110 0.00  
**\*110\*** QC2- Inspect parts off machine FAI/FAIB  
 QC Memo 0.00  
 Quality Control

120 0.00  
**\*120\*** QC8- Inspect parts - second check  
 QC Memo 0.00  
 Quality Control

*counts*  
*40*

*40*

*40*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> Brake NC Brake NC	NC BRAKE  Memo DeburrForm on CNC Brake as per Dwg D2583	0.00 0.00				(40)			
140 <b>*140*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00				(center) (40)			
150 <b>*150*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00							

SB 11/11/22

S 11/11/22

11 - 11 - 23 (40)

W/O:		WORK ORDER CHANGES					
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 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 <b>*160*</b> Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Memo START TIME: <u>2:40</u> OVEN TEMPERATURE: FINISH TIME: <u>3:10</u>									
W118439 3200F									
170 <b>*170*</b> QC Quality Control	QC3- Inspect Part Finish	0.00							
Memo 40 BR 11-11-29									
180 <b>*180*</b> Packaging Packaging	Identify as per dwg & Stock Location <u>17</u>	0.00							
Memo 11/11/30 (40)									

40XØ M-L 11/11/29

40 BR 11-11-29

11/11/30 (40)

W/O:		WORK ORDER CHANGES					
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 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
<b>*190*</b>									
QC	Memo	0.00							
Quality Control									

11/12/11   
 11.11.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Friday, November 04, 2011 2:59:26 PM

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Work Order ID: 76074

**\*76074\***

Parent Item: D2583

**\*D2583\***

Parent Item Name: Latch Bracket

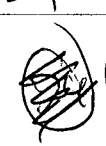

Start Date: 11/4/2011

Required Date: 11/11/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat- in house processDM  
IPP: D06.07.21 Waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.040		Purchased	No			100	sf	96.0000	0.1169	4.922105			
									**			B11-11-7	
													
						<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
						MAT022		96					
						119384		96				119384	

**\*M5052H32S 040\***

5052-H32 .040 Sheet

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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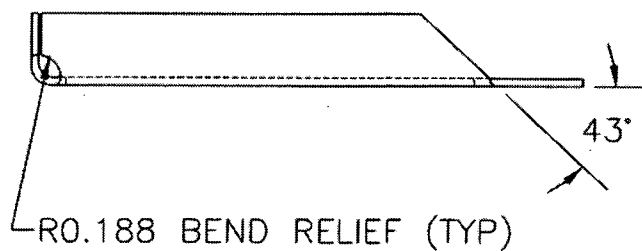
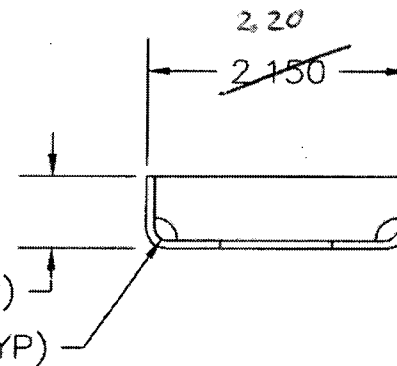
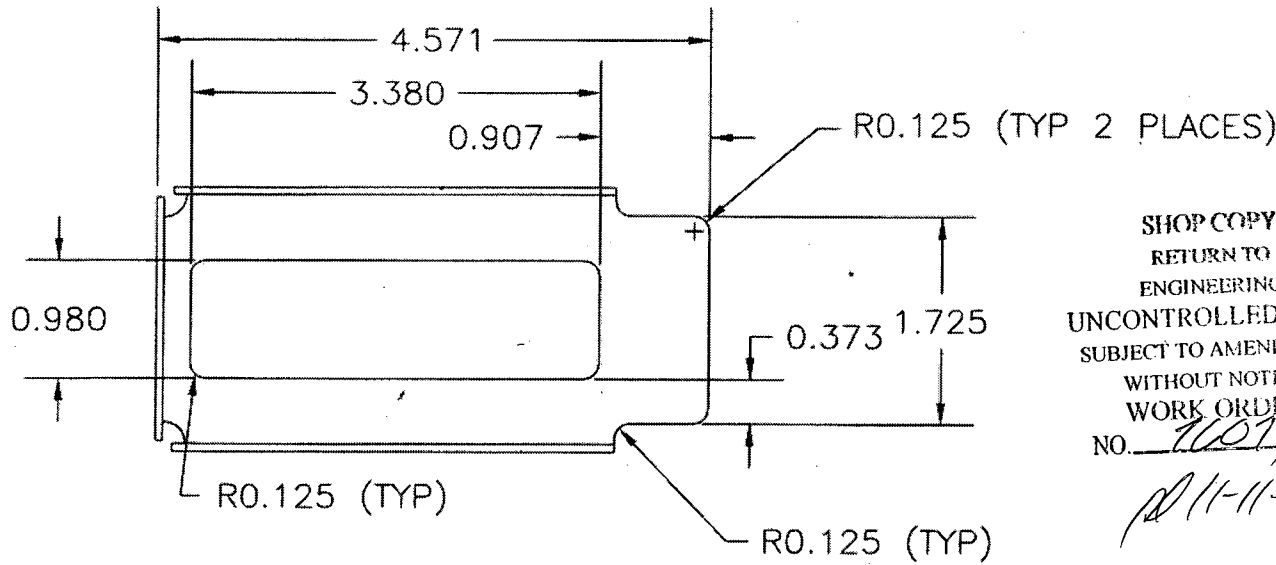


RELEASED  
KE 99.02.25

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 76074

11-11-07  
KE 99.02.26

DESIGN	MIKE M.	DRAWN BY	RE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	CP	APPROVED	KE	DRAWING NO. D2583
DATE	99.02.22	TITLE	LATCH BRACKET	REV. B
				SHEET 1 OF 1
				SCALE 2:3
A	96.07.10	NEW ISSUE		
B	99.02.22	CHANGE OF FINISH (PER TSR A887)		



MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
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